Work Orde September-23-13				*1072	260*			·			Page 1
Revision ID:	D3198-1 Fitting		3198-1 107260	Accept	*N900	<u>040</u>	100) *	Setup Sta	ı Vı	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	ID:					
Approvals:		- H	Date: <i>13-09-23</i> Date:	Tooling: SPC (Y/N):		ate:		I	Run Sta Sto	171	R1*
Sequence ID/ Work Center II	0	peration Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisi	on Nbr									
D3198	Rev A										
100 *100* Waterjet FLOW CNC Waterje 304-125*		LOW WATER JET Memo 1-Cut as po Deburr if n	er Dwg D3198 Dwg Rev:_ necessary	0.00 0.00 Prog Rev: 4	_ 2-			_12			J <u>m 13.13</u> -7
*110 *110* QC Quality Control	Ç)C2- Inspect parts off i	machine FAI/FAIB	0.00	·			_13	<u> </u>		Jm 13-12.
¹²⁰ *12∩*	C	QC8- Inspect parts - se	cond check	0.00 B S C	>			ÍQ.			·
QC		Memo		0.00	1						

Quality Control

NCR:	res /	No				WORK ORDER NON-O	100	NFORM	MANCE / UPDATE		•		
											QA Closed:	Date:	
Work Orde	oř.				!	DISPOSITION			AGAINST D)E	PARTMENT	PROCESS	
Part N	 No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other													
Process	H												
Supplier	\square												
Training	П				,								
Unapproved	П												·
						F	ΑUL	LT CATE	GORY			·	
Landi	ng Ge	ar				General		_			_		
	В	ending				Bend		Grain			Ovalized		Pressure/Forced
	Щc	entre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	∐C ₁	acks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	t	Weld
	-		Crimped		<u> </u>	Burrs	L	-1	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
		uffs				Contamination		Mainte	-		Part Moved		
	$\boldsymbol{\vdash}$	eat Trea			<u> </u>	Countersink	\vdash	Mislabe	<u> -</u>		Positioned V		7
	$\boldsymbol{\vdash}$		n Strip in	Tube		Cut Too Short	\vdash	Misread	Ĺ		Power Loss/	Surge	Other
	∐ Ri	pples in	Bend			Drill Holes	L	Offset					
1	Te	orque W	laves in E	extrusio	n	Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde September-23-1.				*107	7260*						Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3198-1 Fitting 9/23/13 9/23/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	Accept	*N900 Cust Item I Customer:		100)* s	Setup Start	i VI	S1* S2*
Approvals:	Process P	lan:	Date:	Tooling: _ SPC (Y/N):		ate:		R	Run Start Stop		R1* R2*
Sequence ID/ Work Center II 130 *120* Brake NC Brake NC	D	Operation Description NC BRAKE Memo 1-Deburr if	necessary 2-Form as per	Set Up/ Run Hours 0.00 0.00 Dwg D3198	Tool ID	Tool # DAS 30 9-89	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*140 *140* QC Quality Control		QC5- Inspect part comp	eteness to step on W/O	0.00 DAS 27 0.00)				12			-046 -541 -549

150

150 Powdercoat

Powder Coating

0.00

Memo

OVEN TEMPERATURE:

12 13-12-11

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

												QA Closea:	νa	te:	
Work Orde	er: _	######################################				DISPOSITION	,			AGAINST D	EP	ARTMENT			
Part N						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		nitial	A	ction	Т	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator															
Material															
Setup						JA									•
Other						,									
Process															
Supplier							ļ				1				
Training												·			
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	-					F	AUL	T CATE	GORY						
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-		Bending			ļ <u>.</u>	Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa				Over/Under			Temperature/Cure
		Cracks			L	Broken/Damaged	\vdash	ł .	ion Incomplete	_		Part Incorrec		<u> </u>	Weld
1	_	Crushed/0	Crimped		<u> </u>	Burrs	\vdash	i	ions Incomplete	/Unclear	-	Part Lost/Mi	ssing		Wrong Stock Pulled
	<u> </u>	Cuffs				Contamination	<u> </u>	Mainte		L	_	Part Moved			
	<u> </u>	Heat Trea				Countersink		Mislabe		L	_	Positioned W	-	_	1
		Inspection	•	Tube		Cut Too Short		Misread	d			Power Loss/S	Surge	<u></u>	Other
		Ripples in			_	Drill Holes		Offset	- ## .:		_				
	<u> </u>	Torque W			n	Drawing	-	1	Calibration		-				
	\vdash	Turning S			<u> </u>	Finish	_	•	Sequence		-				
<u> </u>	<u> </u>	Wave/Tw	ist in Tub	oe		Folio		Outside	Dimensions						

Work Orde September-23-1.					*107	7260*						Page 3	
Item ID: Revision ID: Item Name:	D3198-1 Fitting				Accept	*N900	040	100)* 5	Setup St St	1 7	IS1* IS2*	
	9/23/13	Start Qty: 8.00 Req'd Qty: 8.00		*8* *8*		Cust Item I Customer:	D:				•	10 17	
Approvals:	Process P	lan:	Date:		Tooling: SPC (Y/N):		nte:		I		art * N top * N	JR1* JR2*	
Sequence ID/ Work Center II 160 *160* QC Quality Control)	Operation Description QC3- Inspect Part Finish Memo			Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Numbe	. / /	W
170 *170* Packaging Packaging		Identify as per dwg & Sto	ock Location	SJƏYI	6.A 0.00 0.00				DA 32 9-8	s //	3/12/10	: (12)	/
180		QC21- Final Inspection -	Work Order	Release	0.00						1)	.~4	

0.00

Memo

*18**0***

Quality Control

13/12/18 TO MF 13-12-18-

						•				DQA:	Date	2:
NCR: Y	es / No				WORK ORDER NON-O	100	VFORN	MANCE / UP	DATE			-
					_					QA Closed:	Date	2:
Work Orde	r i.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.				Scrap	1	i	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•				Use-as-is	1	Therm	oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update]		Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						1						
Operator											:	
Material												
Setup						Ì						
Other												
Process		1										
Supplier												
Training												
Unapproved										<u> L</u>		
						AUI	LT CATE	GORY				
Landir	ng Gear			_	General	_	-			-	-	
	Bending			<u> </u>	Bend	<u></u>	Grain			Ovalized	_	Pressure/Forced
·	Centre N	lot Conce	ntric to	o/s	BOM/Route	_	Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		4	on Incomplete	_	Part Incorre		Weld
		/Crimped		L	Burrs		-	ions Incomplete/	'Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tre	at		ļ	Countersink	L	Mislabe	led	<u>L</u>	Positioned \	Wrong	
	Inspection	on Strip in	Tube	L	Cut Too Short		Misread	l		Power Loss,	'Surge	Other
	Rinnles i	n Rend			Drill Holes	1	Offcat					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Picklist Print

September-23-13 11:44:48 AM

Work Order ID:

107260

Parent Item:

D3198-1

Parent Item Name:

Fitting

Start Date: 9/23/13

Required Date: 9/23/13

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: A03.11.11New IssueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	•	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	235.0833	0.105	0.8842104		JY	~1 <u>3-12</u> -
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT020		235.0832632							
					122521	19.1432632							
					124445	46.52			-				
					M126075	169.42			196	ZEO.			

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORN	MANCE / UF	PDATE		·			
											C	QA Closed:	Da	ite:	
Work Ord	er.					DISPOSITION			•	AGAINST DI	EP/	ARTMENT	PROCESS		
, work ord	-				·-·	Rework	1		Skid-tube	Crosstube	7		Water Jet		Engineering
Part I	No.					Scrap	1		Machining	Small Fab	1	Proc	d. Eng. Coor.	-	Quality
	•					Use-as-is]	Therm	noforming	Finishing]		e/Packaging	_	Other
NCR I	۷o.				· 	Work Order Update			Large Fab	Composite			Supplier	·L	
Root					Descri	tion of work order update		nitial	A	ction	Τ	Sign &			
Cause		Date	Step	Qty	ł.	or Non-conformance	Ch	ief Eng	Des	cription		Date	Verification	n	QC Inspector
Doc/Data															
Equip/Tooling															
Operator	Ш														
Material															
Setup															
Other															
Process															
Supplier											1				
Training															
Unapproved			<u> </u>												
						F	AUL	T CATE	GORY						
Landi	ng C	Gear				General		_			_				_
1		Bending				Bend		Grain			_ c	Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re		_ c	Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		_ P	art Incorred	ct .		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete	/Unclear	_]P	Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination]Mainte	nance]P	Part Moved			_
ļ		Heat Tre	at			Countersink		Mislabe	led] P	ositioned V	Vrong	_	_
	\Box	Inspectio	n Strip in	Tube		Cut Too Short		Misreac	1		٦p	ower Loss/	Surge	Г	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	167248
Description: Fitting	Part Number:	D3198-1
Inspection Dwg: D3198 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

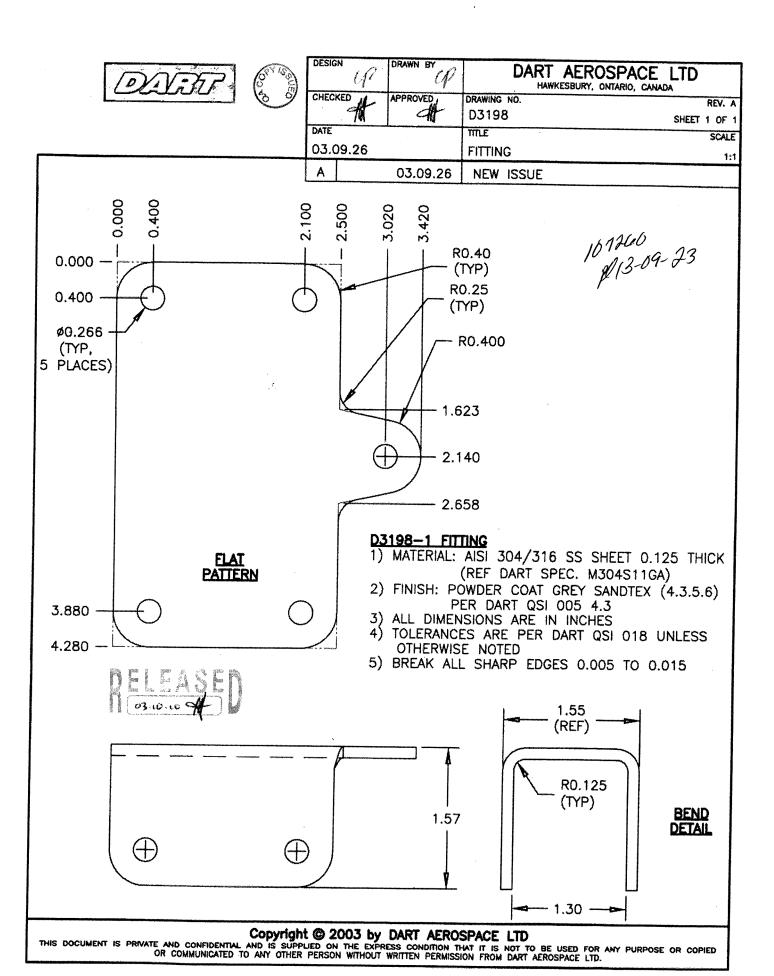
X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266	+0.006/-0.001	0.263		1	U	gkmoi
4.280	+/-0.010	4.283	_		U	J
2.500	+/-0.010	2-504"	_		V	
3.420	+/-0.010	3.423		-	V	
0.400	+/-0.010	6.401"	_		V	
0.400	+/-0.010	0.403"	_		U	
3.880	+/-0.010	3 884	_		V	
2.100	+/-0.010	2-106	_		6	
3.020	+/-0.010	3022			V	
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Measured by:	Jm	Audited by:	SMP	Prototype Approval:	N/A
Date:	3-2-1	Date:	B. 12.9	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.13	New Issue	KJ/JLM	
В	08.05.28	Ø0.266 was Ø0.270	KJ/DD X	13/
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